May-23-13 11:32:59 AM

102072

Page 1

Item ID: Revision ID:	D4020-11			Accept	*N900	1040	1100)*			*N	S1*
Item Name:	End Mesh, B	Basket	,							Stop	*N	S2*
Start Date:	5/23/13	Start Qty: 20.00	*20*		Cust Item	ID:						
Required Date	: 6/06/13	Req'd Qty: 20.00	*20*		Customer:	:						
Reference:												
Approvals:	Process Pl	lan: ML5	Date: 13-05-23	Tooling:	D	Pate:]		Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	Date:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr				,						
D4020	Α											
100		,		0.00					,	18.1		
100		FLOW WATER JET						24		0		JM13-07-0
Waterjet		Memo	D 04000	0.00								
FLOW CNC Water	jet	Dwg Rev:	Dwg D4020									a r dit
55. Mes	ik .	Prog Rev:_ 2-Deburr if	necessary									#
-110°		QC2- Inspect parts off m	nachine FAI/FAIB	0.00								
110								24	/			JM13-07-0
QC		Memo		0.00				47				<u> </u>
Quality Control		***CUT OL BASKET**	JTS WILL BE CUT BY WE *	LDERS WHEN INS	STALL ON							
120		QC8- Inspect parts - seco	and check	0.00 AS			Ĺ	who -				,
120		Mome		0.00 PAS 16 9-89	3/0/2			(424)	<u>) —</u>			
Quality Control		Memo ***CUT OU BASKET**	JTS WILL BE CUT BY WE *									

												DQA:	Da	te:		
NCR: Y	'es	/ No				WORK ORDER NON-O	OI	VFOR	MANCE / UPE	DATE	C	QA Closed:	Da	te:		
Work Orde	er:				-	DISPOSITION				AGAINST D	EP/	ARTMENT/	PROCESS			
Part N	•					Rework Scrap Use-as-is		Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other	
NCR N	10.					Work Order Update]		Large Fab	Composite			Supplier	Ш		
Root Cause		Date	Step	Qty	Desc	otion of work order update	1	Initial nief Eng	Acti Descr	ion iption		Sign & Date	Verificatio	n	QC Inspector	
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upplier raining																
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		Centre No Cracks		itric to	U/S	BOM/Route Broken/Damaged		4 .	on Incomplete		P	Over/Under Part Incorrec	:t		Temperature/Cure Weld	
		Crushed/0	Crimped			Burrs	\vdash	4	ions Incomplete/L	Jnclear	_	Part Lost/Mi	ssing		Wrong Stock Pulled	
		Cuffs				Contamination	<u> </u>	Mainte		-		Part Moved				
		Heat Trea		T., b -		Countersink	-	Mislabe		\vdash	→	Positioned W	_		امياء	
	_	Inspection		rupe		Cut Too Short	\vdash	Misread	1	L	۳	Power Loss/:	Surge		Other	_
		Ripples in		·		 Drill Holes	\vdash	Offset	7-1:h+:		_					
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		Turning S	equence		1	Finish	1	IOut of S	Seauence							

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord May-23-13 11		02072		*102		Page 2	
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D4020-11 End Mesh, B 5/23/13 e: 6/06/13	asket Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*	Accept \int	*N900040100* Cust Item ID: Customer:	Setup Start Stop	11/21
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date: Date:	Run Start Stop	"NR1"
Sequence ID/ Work Center 1 130 *130* Packaging Packaging	ID	Operation Description Identify as per dwg & Stor	ck Location: WA	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Acc Code Oty	Reject Qty	Reject Insp. Number Stamp
140		QC21- Final Inspection - V	Work Order Release	0.00		131	1/k2A

0.00

Memo

Quality Control

13/7/8 AT 13-7-5

NCR: Y	es/	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPD	ATE			
						_					QA Closed:	Date	:
Work Orde	r:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work or at	•			···········		Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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NCR N	۱o. ِ					Work Order Update]		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ċh	ief Eng	Descri	ption	Date	Verification	QC Inspector
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		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct	Weld
	L	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/Mi	issing	Wrong Stock Pulled
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		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples ir	n Bend			Drill Holes	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

May-23-13 11:33:03 AM

Work Order ID: 102072

D4020-11

102072

Parent Item Name: End Mesh, Basket

D4020-11

Start Date: 5/23/13

Required Date: 6/06/13

Start Qty: 20.00

Required Oty: 20.00

Comments:

Parent Item:

IPP RevA: new issue DD 09.11.26 verified by;EC

per dwg revA 10.03.15 verified by:EC

IPP Rev:B as IPP Rev:C 10.06.14 remove

cut out from dxf, will be made when install on basket DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	1,322.815	2.694	-16.71579)		
*M304FX(Expanded Metal Flat SS) 75-16F	- *							**	60			ImB07-0
				Location	<u>!</u>	Loc C	<u> Dty</u>	Loc Code					
				MAT		176.2791	180						
					125113	176.279	118		_				
				WA			447						
					125457		447		_				
				WA007		699.	536		_				
					123448	15	5.96		_				
					125457	203.	576						
					125605		480						

136053 x

126052

				·					DQA:	Date:	
NCR: Ye	s / No			WORK ORD	ER NON-COI	NFORN	AANCE / UP		QA Closed:	Date:	
\\\\-\-\-\-\-\-\-\-\-\-\-\-\-\-\-\-\				DISPOS	ITION			AGAINST DE			· · · · · · · · · · · · · · · · · · ·
Work Order: Part No					Rework Scrap	r	Skid-tube Aachining	Crosstube Small Fab		Water Jet	Engineering Quality
NCR No)			Work Orde	Use-as-is r Update		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Description of work ord	er update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	or Non-conforma	nce Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process		1									
Supplier								:			
Training											
Unapproved	1										
	-				FAUI	LT CATE	GORY				
Landing	g Gear			General	,						

Grain Ovalized Pressure/Forced Bend Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Part Incorrect Broken/Damaged Inspection Incomplete Weld Cracks Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Cuffs Maintenance Part Moved Contamination Heat Treat Countersink Mislabeled Positioned Wrong Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short **Drill Holes** Offset Ripples in Bend Torque Waves in Extrusion **Drawing** Out of Calibration Out of Sequence Turning Sequence Finish

Outside Dimensions

Wave/Twist in Tube

DART AEROSPACE LTD	Work Order:	102072
Description: End Mesh, Basket	Part Number:	D4020-11
Inspection Dwg: D4020 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

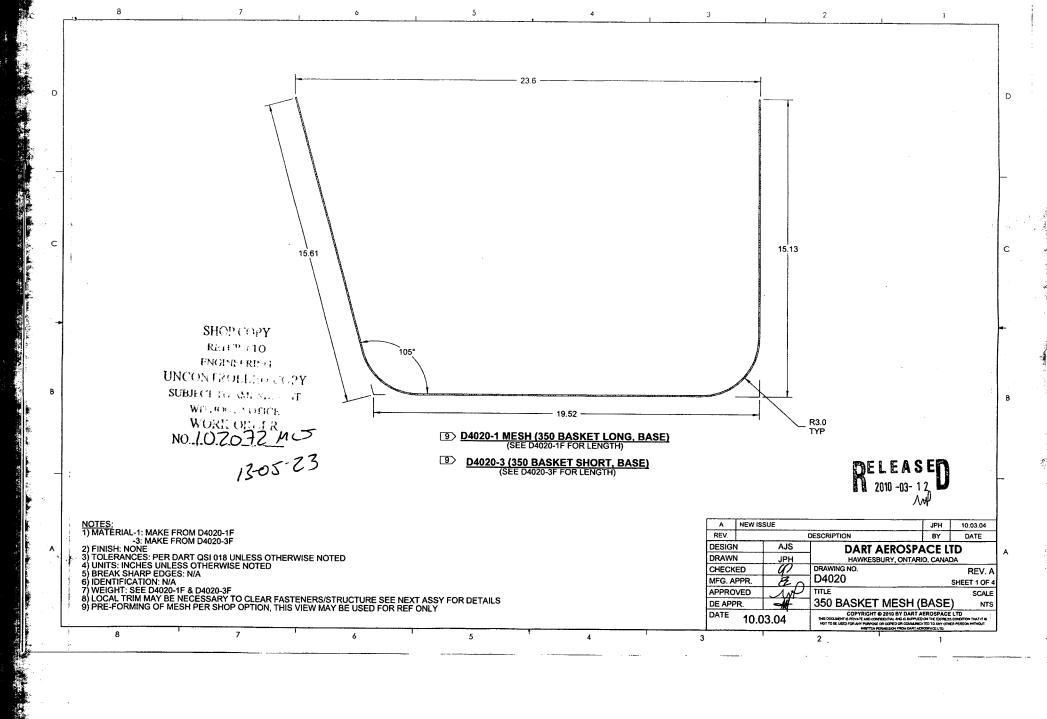
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.34	+/-0.030	24.34"	_		丁	J4mob
2.88	+/-0.030	2.89"	_		V	Jones -
17.31	+/-0.030	17.31"	_		ァ	
15.50	+/-0.030	15.50	_		7	
20.18	+/-0.030	20.18	_		丁 -	
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Measured by:	Jm.	Audited by:	0/0	Preliminary Approval:	N/A
Date:	13-07-03	Date:	9-89 Blog	Date:	N/A

Rev	Date	Change	Revised by	Approved
_ A	10.04.01	New Issue	KJ 10	16
В	10.08.03	Dimensions updated	KJ (E)	X

												DQA:	Date	e: _	
NCR: Y	'es	/ No					WORK ORDER NON-C	O	NFORM	MANCE / UPDATE					
												QA Closed:	Date	e:	
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Part N	•						Rework Scrap Use-as-is		ſ	Skid-tube Crosstube Machining Small Fab noforming Finishing		4	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	lo.						Work Order Update]		Large Fab Composite			Supplier		
Root					Desc	rip	tion of work order update		nitial	Action		Sign &			
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		Cracks Crushed/0	Crimnod		}	\neg	Burrs	\vdash	4	tions Incomplete/Unclear	\vdash	Part Lost/Mi	} _	-	Wrong Stock Pulled
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		Heat Trea	it		}	_	Countersink	\vdash	Mislabe		\vdash	Positioned V	Vrong		
		Inspection		Tube	ŀ		Cut Too Short		Misread			Power Loss/			Other
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		Torque W		Extrusion	, ի	-	Drawing		1	Calibration					
		Turning S			ļ		Finish		Out of 9	Sequence					
		Wave/Tw			ľ		Folio		4	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



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											DQA:	Date:				
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Part N	lo.					1	Scrap Machining Small Fab				Pro	Quality				
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NCR N	lo.					Work Order Update			Large Fab	Composite]	Supplier				
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		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre		Weld			
		Crushed/	Crimped		F	Burrs		-1	tions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
		Cuffs	•		ļ-	Contamination		Mainte	enance		Part Moved		•			
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Wrong				
	Inspection Strip in Tube Cut Too Short							Misrea	d		Power Loss/	Other				
		Ripples ir	n Bend			Drill Holes		Offset				-				
		Torque V	Vaves in I	Extrusio	n [Drawing		Out of	Calibration							
		Turning S	Sequence	!		Finish		Out of	Sequence							

Wave/Twist in Tube

D4020-5: 95.25 D4020-7: 56.00 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 D4020-5 MESH (350 BASKET LONG, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY) D4020-7 MESH (350 BASKET SHORT, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F REF DART SPEC. M304EX0.75-16F

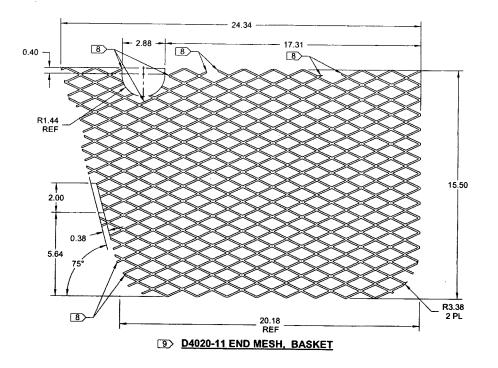
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 2 OF APPROVED TITLE 350 BASKET MESH (BASE) DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD

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										DQA:	Date:			
NCR: Yes	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UP	DATE	046	0-1-			
							-			QA Closed:	Date:			
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Order.					Rework		Skid-tube Crosstube			7	Water Jet	Engineering		
Part No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
				··	Use-as-is]		noforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR No.					Work Order Update]		Large Fab	Composite]	Supplier			
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Root					ption of work order update		Initial		tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector		
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Operator						ļ								
Material	}					1								
Setup	<u> </u>										ļ			
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Training														
Unapproved										<u> </u>				
					F	AUI	T CATE	GORY						
Landing	Gear		-		General									

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Γ	Bending	Bend	Grain	Ovalized	L	Pressure/Forced
Γ	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	L	Temperature/Cure
Γ	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	L	Weld
Γ	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
ſ	Cuffs	Contamination	Maintenance	Part Moved		
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	_	_
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	L	Other
	Ripples in Bend	Drill Holes	Offset			
	Torque Waves in Extrusion	Drawing	Out of Calibration			
	Turning Sequence	Finish	Out of Sequence			
Γ	Wave/Twist in Tube	Folio	Outside Dimensions			



D

NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F

REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE 350 BASKET MESH (BASE) DE APPR. DATE

10.03.04

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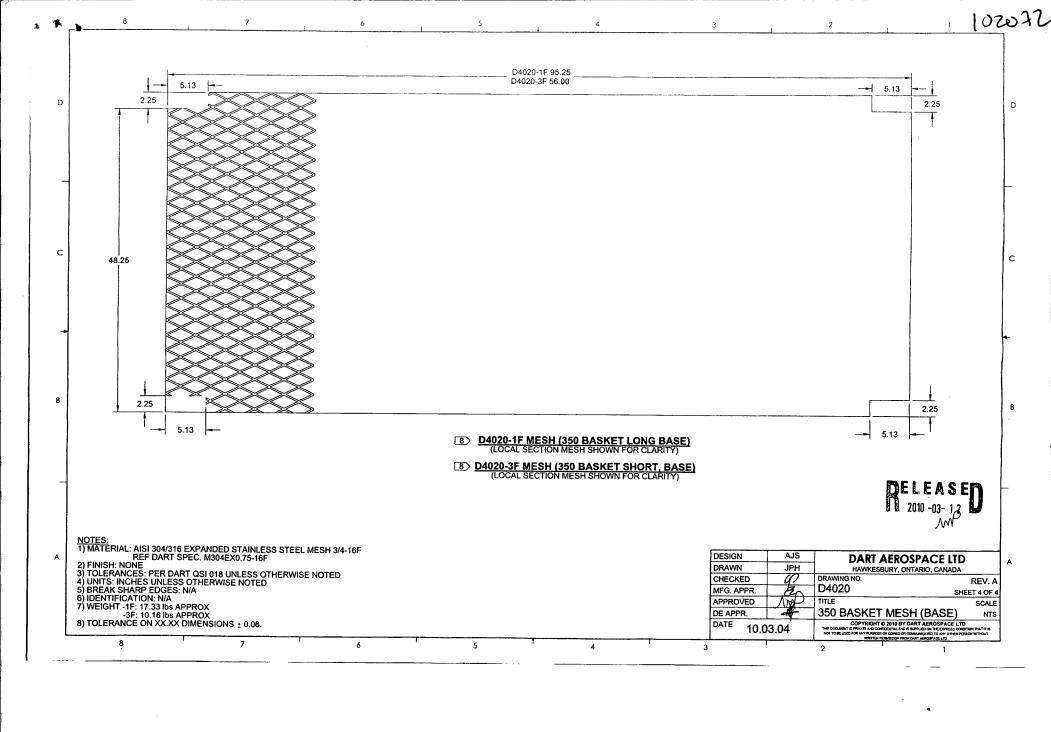
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WRITTEN REPOSESSOR FROM DART AEROSPACE LTD.

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NCR: Y	es	/ No					WORK ORDER NON-C	CON	NFORM	AANCE / UP	PDATE	QA Closed	· Da	ite:	· · · · · · · · · · · · · · · · · · ·	
						T	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Nork Order:						ł					_	_				
Part No.							Rework Scrap Use-as-is		ľ	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR No.							Work Order Update	┦ ▮ ~——			Composite		Supplier	-		
Root		-			Desc	rip	tion of work order update		nitial	Ac	ction	Sign &				
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	'n	QC Inspector	
oc/Data quip/Tooling Derator Material etup Other Process upplier Training																
Inapproved				1				Διι	T CATE	GORY		L	.1		1	
Landir	ne G	Gear		·····			General									
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion						Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorr Part Lost/N Part Move Positioned Power Lost	Aissing d Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Turning Sequence						Finish		Out of 9	Sequence						

Wave/Twist in Tube



DQA: Date:

NCK: YE	es / No				WORK ORDER NON-C	JOIN	ruki	VIAINCE / UPI	DAIE	QA Closed:	Date	<u>:</u>		
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality		
NCR N	0	<u>.</u>			Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other		
Root	10 244			Descri	ption of work order update		Initial Action			Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling														
Operator	4	}							•					
Material	4				,				:					
Setup	-} ·		1	7										
Other	_													
Process	4					1				ı				
Supplier		1				1								
Training														
Unapproved		<u>i</u>	<u> </u>			ALILT	CATE	GORY			<u> </u>			
Landin	g Gear	•	-, :		General	AULI	CAIL	<u> </u>						
	Bending				Bend	\Box	Grain			Ovalized	Γ	Pressure/Forced		
<u> </u>	Centre Not Concentric to O/S Cracks				BOM/Route	\vdash	Hardware			Over/Under	tolerance	Temperature/Cure		
-					Broken/Damaged	-		ion Incomplete		Part Incorre	 	Weld		
ţ	Crushed/Crimped				Burrs	₩	Instructions Incomplete/Unclear			Part Lost/Mi		Wrong Stock Pulled		
<u> </u>	Cuffs				Contamination	_	Maintenance			Part Moved	_	_		
Ţ	Heat Treat				Countersink	H	Mislabe	eled		Positioned V	Vrong			
İ		on Strip in	Tube		Cut Too Short	∏,	Misrea	d		Power Loss/	'Surge	Other		
ļ	Ripples i			2	Drill Holes	П	Offset			•	<u>. </u>			
ŀ	→ · ·	Waves in	Extrusio	n —	Drawing	П	Out of	Calibration						
		Sequence			Finish	П	Out of !	Sequence						
		vist in Tu			Folio		Outside	e Dimensions						